

Work Order ID 158130

Friday, March 10, 2017 3:43:07 PM

158130

Page 1

Item ID: D3213-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Interior Door For -015 & -025
Start Date: 3/22/2017 Start Qty: 3.00 ***3*** **5** **MLJ** Cust Item ID:
Required Date: 3/17/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference: SCHEDULED/S
Approvals: Process Plan:  Date: MAR 10 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3213	B								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.09							
Small Fab	1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520								
	Identify as D3213-041								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
120									
Powdercoat	Memo	0.05							
Powder Coating	START TIME: 9:00 OVEN TEMPERATURE: 320 FINISH TIME: 9:00								

Pick kit 5 **MAR 16 2017** **DAS 6 9-89** **17/03/22** **5x** **DAS 36 9-89** **5** **DAS 33 9-89** **MAR 22 2017** **5 φ 17-03-28** **33 9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

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NS1

NS2

Customer:

NR1

NR2

**Insp.
Stamp**

DAS
38
9-89

MAR 28 2017

17/03/29

Small Fab

DAS
38
9-89

MAR 29 2017

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Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

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158130

Page 3

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Start Date: 3/14/2017 Start Qty: 3.00 ***3*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST437</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.05							
Quality Control									

17/4/30

DAS
21
9-89
MAR 31 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 158130

158130

Parent Item: D3213-041

D3213-041

Parent Item Name: Replacement Interior Door For -015 & -025

Start Date: 3/14/2017

Required Date: 3/17/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2137		Manufactured	No			140	Each	16.0000	1	3			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2137

Decal(No Step)

17/03/29 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

16

141995

4

156103

6

150061

6

2/2/2017

9/7/2017

5

D2419		Manufactured	No			140	Each	10.0000	1	3			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2419

Handle

17/03/29 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

10

150276

3

155319

3

156242

4

3
2

D2462		Manufactured	No			140	f	334.0683	2.4	7.2			
-------	--	--------------	----	--	--	-----	---	----------	-----	-----	--	--	--

D2462

Neoprene Seal (\$Per foot)

17/03/29 DAS 36 9-89

Location

Loc Qty

Loc Code

ST408

334.0683

115832

334.0683

12

D2728-1		Manufactured	Yes			140	Each	8.0000	1	3			
---------	--	--------------	-----	--	--	-----	------	--------	---	---	--	--	--

D2728-1

Dart Logo Label Small

17/03/29 DAS 36 9-89

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

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Page 2

Work Order ID: 158130

158130

Parent Item: D3213-041

D3213-041

Parent Item Name: Replacement Interior Door For -015 & -025

Start Date: 3/14/2017

Required Date: 3/17/2017

Start Qty: 3.00

Required Qty: 3.00

D3161-3 Manufactured No

100 Each 10.0000 2 **8/10**

D3161-3

Hinge

MAR 16 2017

DAS 6 9-88

Location

Loc Qty

Loc Code

ST483

6

150209

6

ST488

4

134575

4

D3213-1 Manufactured No

100 Each 9.0000 1 **3/5**

D3213-1

Door Panel

MAR 16 2017

DAS 6 9-88

Location

Loc Qty

Loc Code

ST484

9

102995

3

150372

6

D3213-3 Manufactured No

100 Each 8.0000 1 **8/5**

D3213-3

Door Panel

MAR 16 2017

DAS 6 9-88

Location

Loc Qty

Loc Code

ST484

8

135378

2

150137

6

150209

2
123332 k3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Parent Item: D3213-041

D3213-041

Parent Item Name: Replacement Interior Door For -015 & -025

Start Date: 3/14/2017

Required Date: 3/17/2017

Start Qty: 3.00

Required Qty: 3.00

MS20470AD4-4

Purchased

No

140

Each

2,731.070

24

72

MS20470AD4-4

Rivet, Universal Head

17/03/22
DAS
36
9-89

Location

Loc Qty

Loc Code

CCK004

0.001

M135133

0.001

M136851

0

GA

2351.069

M134294

101

M134848

378

M135133

0.069

M135536

67

M136042

93

M136301

213

M136851

1499

ST310

380

M132803

380

22/20

MS20470AD4-6

Purchased

No

100

Each

2,156.000

1

MS20470AD4-6

Rivet, Universal Head

17/03/29
DAS
36
9-89

Location

Loc Qty

Loc Code

CCK004

1566

m136787

1566

GA

368

m133077

368

ST310

222

m134852

222

5

DQA: _____ Date: _____



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Picklist Print

Friday, March 10, 2017 3:43:06 PM

Page 4

Work Order ID: 158130

158130

Parent Item: D3213-041

D3213-041

Parent Item Name: Replacement Interior Door For -015 & -025

Start Date: 3/14/2017

Required Date: 3/17/2017

Start Qty: 3.00

Required Qty: 3.00

NAS1149DN632J

Purchased

No

140

Each

338.0000

1

35

NAS1149DN632.J

Washer

Location

Loc Qty

Loc Code

ST265

338

m134370

338

MAR 16 2017

DAS
6
9-89

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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